



Dart Aerospace Ltd.
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DSK078

Job Sheet 187510



Part No: DSK078

Job Qty: 12 ea

Part Name: D2893-1 Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/18

Job Tracking No:

Due Date: 1/4/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Machining-4		
100	Doosan	12 pcs	1/4/19	1/4/19	0.50	10.53	Doosan		
110	QC	12 pcs	1/4/19	1/4/19	0.00	0.00	QC2 Machining-4		
120	QC	12 pcs	1/4/19	1/4/19	0.00	0.00	QC8 Machining-4		
130	Packaging	12 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea	1/4/19	1/4/19	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)
Descriptions: 130 - LOCATION: MAT060

DAS
21
9-80

JAN 25 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-005	Round Billet, 17-4	120 Ea (10 ea)	90-Start up Operation	5/24/201

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-005	120	69	0

Part Specifications

Specifications could not be found.



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Plex 12/6/18 10:19 AM dart.white.jesse

Container No: S145059



Part: DSK078

Job No: 187510

Serial No/Batch: S145059

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/16/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 187510
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**

 ☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.708	2.709	2.7085	2.709	
B	4.946	4.966		4.954	4.953	4.954	4.955	
C	3.064	3.084		3.0745			3.0745	
D	0.718	0.738		.729			.7275	
E	0.090	0.110		.098			.098	
F	2.934	2.954		2.9435			2.9435	
G	2.166	2.186		2.1755			2.1745	
H	3.890	3.910		3.9			3.9	
I	0.914	0.934		.923			.925	
J	0.022	0.042		.032	~~~~~			
K	0.109	0.129		.118				.117
L								
M								
N								
O								
P								

Measured by: Dave C. [Signature] **Date:**

Audited by: 10/01/16 and 19/01/24 **Date:**

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]